

Work Order ID 91674 -2

October-15-12 10:01:18 AM

\*91674\*

Page 1

Item ID: D205-708-011

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Adjustable Engine Mount

Start Date: 10/15/12 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 10/29/12 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: *Q*

Date: 12/10/15 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B80701	Rev C
--------	-------

100

\*1000\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

0.00

0.00

*DA 12/10/14*

*for mls 12-11-15 (2)*

110

\*110\*

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 18123 for:

✓ 6	D3284-001	(B80702-1)	Sleeve
✓ 2	D3284-003	(B80703-1)	Stud
✓ 4	D3284-005	(B80704-1)	Stud
✓ 6	D3284-007	(B80705-1)	Stud
✓ 6	NAS509-12	Nut	
✓ 6	NAS509L12	NutStud	

0.00

0.00

*Q 12/10/12 (4)*

To be assembled as per Dwg B80701 Rev. C  
Possible Supplier: Northern Aero  
Certificate of Conformity is required



# Work Order ID 91674

October-15-12 10:01:18 AM

**\*91674\***

Page 2

Item ID: D205-708-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Adjustable Engine Mount

Stop **\*NS2\***

Start Date: 10/15/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/29/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached

*12/11/12 (2)*

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

Inspect assembly. Visually inspect thread, fit and cad plating

*12/11/12*

*72*  
*12/11/12*

135

Pick Kit

0.00

**\*135\***

Packaging

Memo

0.00

Packaging

*4x*

*SP12-11-15*



100

# Work Order ID 91674

October-15-12 10:01:18 AM

**\*91674\***

Page 3

Item ID: D205-708-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Adjustable Engine Mount  
 Start Date: 10/15/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 10/29/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
150 <b>*150*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D205-708-011 Location: <u>QA</u> PPP Rev: <u>A</u>	0.00 0.00							
160 <b>*160*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

54 8 12/11/14

12/11/20

W me  
12-11-16  
20



# Picklist Print .

October-15-12 10:01:17 AM

Page 1

Work Order ID: 91674

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 10/15/12

Required Date: 10/29/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP  
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3284-001 Sleeve ✓		Manufactured	No			140	Each	6.0000	6	24		B 9/16/74 SP	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
					24757	6							
D3284-003 Stud ✓		Manufactured	No			140	Each	5.0000	2	8		B 9/16/74 SP	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		5							
					32724	3							
					35656	2							
D3284-005 Stud ✓		Manufactured	No			140	Each	11.0000	4	16		B 9/16/74 SP	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		6							
					24757	6							
				ST037		5							
					43645	3							
					79831	2							
D3284-007 Stud ✓		Manufactured	No			140	Each	6.0000	6	24		B 9/16/74 SP	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
					24757	6							

SP 12-11-14.











# Picklist Print-

October-15-12 10:01:17 AM

Page 3

Work Order ID: 91674

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 10/15/12

Required Date: 10/29/12

Start Qty: 4.00

Required Qty: 4.00

NAS509-12

Nut

Purchased

No

140

Each

48.0000

6

24/12 - B91674SP

## Location

## Loc Qty

## Loc Code

ST279

48

15057

42

24757

6

140

Each

44.0000

6

24/12 - B91674

NAS509L12

Nut

Purchased

No

## Location

## Loc Qty

## Loc Code

ST280

44

102296

29

15062

9

24757

6

SP 12-11-14

October-15-12 10:01:17 AM

Shop Packet Print

Page 3





# SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



**NOTE:**

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH  
 MIN Ft<sub>u</sub> = 90 Ksi  
 MIN Ft<sub>y</sub> = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

*CL 12/10/15*  
*W10: 91674*

**RELEASED**  
 2010-03-25  
*in*

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3284	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT	NTS
DATE	09.07.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

# PURCHASE ORDER

Purchase Order ID PO18123

Purchase Order Date 10/15/12

PO Print Date 10/16/12

Page Number 1 of 2

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.  
25 DUNLOP AVENUE  
WINNIPEG, MB R2X 2V2  
CA

Contact Name

Vendor Phone 204-772-9922

Vendor Fax 204772-7568

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B80702-1	Sleeve	10/26/12 Yes	24.00 Each	FedEx PI collect	\$117.0000	\$2,808.00
		Special Inst:	D3284-001 Sleeve ACS P/N B80702-1 per ACS DWG B80702 Rev:A				
2	B80703-1	Stud	10/26/12 Yes	8.00 Each	FedEx PI collect	\$98.0000	\$784.00
		Special Inst:	D3284-003 Stud ACS p/n B80703-1 per ACS Dwg:B80703 Rev: A				
3	B80704-1	stud	10/26/12 Yes	16.00 Each	FedEx PI collect	\$87.0000	\$1,392.00
		Special Inst:	D3284-005 Stud ACS p/n B80704-1 per ACS DWG: B80704 Rev: A				

PO Instructions: PLEASE ADVISE DELIVERY

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required **YES** NO

Change Nbr: 2

Change Date: 10/16/12



**ACS-NAI Ltd.**

25 Dunlop Avenue  
R2X 2V2 Winnipeg  
Canada  
Tel : 204-772-9922  
Fax : 204-772-7568

50 27672

Delivery No. : 3243  
Delivery Date : 11/07/2012  
SO No. : 27672  
Your Reference : PQ: 18123  
Delivery Method : FEDEX  
Payment Condition : Net 30 Days

**Delivery to:** Dart Aerospace Ltd.

Attention: Chantal Lavoie  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

B80702-1	SLEEVE 11-4293	24 EA	12	11/26/2012
B80703-1	7/8" STUD 11-4294	8 EA	4	11/26/2012
B80704-1	3/4" MALE STUD 11-4295	16 EA	8	11/26/2012
B80705-1	STUD 11-4296	24 EA	12	11/26/2012
NAS509-12	NUT (.7500-16 UNJF-3B) 11-3879	24 EA	12	11/26/2012
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 11-3686	24 EA	12	11/26/2012
ASSEMBLY	ENGINE MOUNT KIT	4 EA	2	11/26/2012

Ship via FedEx P1 to Account # 151793240  
email: clavoie@dartaero.com

Ph: 613-632-9577

Packages: 0

Gross Weight: 0.00

Net Weight:

**Ordered by:** Dart Aerospace Ltd.

Attention: Chantal Lavoie  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

**Invoice to:** Dart Aerospace Ltd.

Attention: Accounts  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

0.00

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:

07 Nov 12





## 4.0 PARTS LIST

Qty -043	Qty -013	Qty -041	Qty -011	Part Number	Description
			X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
		X		D205-708-041	ADJUSTABLE ENGINE MOUNT ASSEMBLY (205/UH-1)
	X			D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
X				D204-708-043	ADJUSTABLE ENGINE MOUNT ASSEMBLY (204)
	6		6	D3284-001	SLEEVE
			2	D3284-003	STUD
	6		4	D3284-005	STUD
	6		6	D3284-007	STUD
	6		6	D3284-009	BEARING
	1		1	D3284-011	BEARING
1				D3284-021	TUBE ASSEMBLY
1				D3284-023	BIPOD ASSEMBLY
1				D3284-025	TRIPOD ASSEMBLY
		1		D3284-031	TUBE ASSEMBLY
		1		D3284-033	BIPOD ASSEMBLY
		1		D3284-035	TRIPOD ASSEMBLY
	2		2	MS20613-6C12	RIVET
	12		8	MS20613-6C16	RIVET
			8	MS20613-6C18	RIVET
	12		8	MS20613-6C19	RIVET
	6		6	NAS509-12	NUT
	6		6	NAS509L12	NUT

## 5.0 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D205-708-041 Adjustable Engine Mount Assembly (205/UH-1)					
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m
D204-708-043 Adjustable Engine Mount Assembly (204)					

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Revision: A  
Date: 05.07.20

REFERENCE ONLY



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-708 REV. A AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-708 REV. 0

REF. CANADIAN STC SH99-11

REF. FAA STC SR00953NY, SR01395NY

**REFERENCE ONLY**

IT HAS COME TO DART'S ATTENTION THAT THE QUANTITY OF MS20613-6C18/-6C19  
RIVETS IN THE D205-708-011 ADJUSTABLE ENGINE MOUNT KIT IS INCORRECT. THE  
PARTS LIST IS AMENDED AS FOLLOWS:

**WAS:**

Qty -011	Part Number	Description
X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
8	MS20613-6C18	RIVET
8	MS20613-6C19	RIVET

**NOW:**

Qty -011	Part Number	Description
X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
4	MS20613-6C18	RIVET
12	MS20613-6C19	RIVET

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 07.11.14  
CERT. NO.: SH99-11  
ISSUE NO.: 5

A	NEW ISSUE (REF. NCR#198)	MB	07.11.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>[Signature]</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9395	SHEET 1 OF 1
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	PARTS LIST UPDATE	NTS
DATE	07.11.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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